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D3204-041
Job Sheet 188539



Part No: D3204-041

Job Qty: 4 ea

Part Name: Release Pedal Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/10/19

Job Tracking No:

Due Date: 1/15/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	1/15/19	1/15/19	0.00	0.00	Start Up Large Fab-1		<i>EL</i>
100	Large Fab	4 pcs	1/15/19	1/15/19	0.00	5.19	Large Fab 8		<i>EL</i>
110	QC	4 pcs	1/15/19	1/15/19	0.00	0.00	QC9		<i>SA</i>
120	QC	4 pcs	1/15/19	1/15/19	0.00	0.00	QC5		<i>SA</i>
130	HandFinish	4 pcs	1/15/19	1/15/19	0.00	0.38	HandFinish1		<i>D.R. 19/01/19</i>
140	Powdercoat	4 pcs	1/15/19	1/15/19	0.00	0.30	Powdercoat3		<i>BET 19-01-17</i>
150	QC	4 pcs	1/15/19	1/15/19	0.00	0.00	QC3		<i>DAS 36</i>
160	Small Fab	4 pcs	1/15/19	1/15/19	0.00	0.27	Small Fab-3		<i>36 9-89 DAS</i>
170	QC	4 pcs	1/15/19	1/15/19	0.00	0.00	QC5		<i>9-89 DAS 38</i>
180	Packaging	4 pcs	1/15/19	1/15/19	0.00	0.00	Packaging3-1		<i>28 9-89</i>
190	QC21-SA	4 Ea	1/15/19	1/15/19	0.00	0.00	QC21		<i>DAS 21 JAN 28 2019 9-89</i>

Part Op 100 - 1- Pierce a #30 hole center of D3204-5 to let pressure escape while welding. 2- Place parts D3204-1,3,5,13 in jig
Descriptions: number DT10295 for tacking parts together. 3- Remove part from jig and install spacing rods to 6" inside of D3204-3 and
D3204-5; weld parts then after parts have cooled; remove spacing rods... 4- Inside measurement should be @ 5.9". Then
proceed to installing D3204-11 plate, then D3204-9 pedal. 5- Fill #30 hole when parts are cooled to room temperature
quickly at around 150 amps...

1138539 140 - ***Cover holes for bushing*** START TIME: *10:50* OVEN TEMPERATURE: *320°* FINISH TIME: *11:20*
180 - LOCATION : GA

Job BOM

007437

Part / Item	Component Name	Quantity	Operation	Container
D3204-1	Tube	4 pcs (1 ea)	90-Start up Operation	<i>5097143</i>
D3204-11	Plate	4 pcs (1 ea)	90-Start up Operation	<i>5114240</i>
D3204-13	Gusset	8 pcs (2 ea)	90-Start up Operation	<i>5109101</i>
D3204-3	Arm	4 pcs (1 ea)	90-Start up Operation	<i>5096127</i>
D3204-5	Arm	4 pcs (1 ea)	90-Start up Operation	<i>5089779</i>
D3204-9	Pedal	4 pcs (1 ea)	90-Start up Operation	<i>5096583</i>
D3204-7	Bushing	8 pcs (2 ea)	160-Small Fab	<i>5036911</i>

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3204-1	4	20	0
	D3204-11	4	13	0
	D3204-13	8	36	0
	D3204-3	4	12	0
	D3204-5	4	6	0
	D3204-9	4	12	0
160-Small Fab	D3204-7	8	32	0
Part Specifications				
Specifications could not be found.				

Plex 1/10/19 1:34 PM dart.lacelle.linda

DOA:

Date:



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WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Container No: S143892



Part: D3204-041

Job No: 188539

Serial No/Batch: S143892

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/10/19

DISPOSITION

Rework ☐Scrap ☐Use-as-is ☐Improved ☐Skid-tube ☐Machining ☐Thermoforming ☐Large Fab ☐

AGAINST DEPARTMENT/PROCESS

Cross tube ☐Small Fab ☐Finishing ☐Composite ☐Water Jet ☐Prod. Eng. Coord. ☐Rec/Store/Packaging ☐Supplier ☐Engineering ☐Quality ☐Other ☐

QTY Effective :

MRB (QSI042) Approval

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

Root Cause

Environment ☐Design ☐Doc/Data ☐Equip/Tooling ☐Handling/Pre ☐Material ☐Internal Transport ☐Tribal Knowledge ☐LOA ☐Substation ☐Past Expiry Date ☐Misidentified ☐No Re-verification ☐Operator ☐Offset/Setup ☐Supplier ☐Training ☐Use for Testing ☐Poor Information ☐Rushing ☐Product Improvement ☐Process Improvement ☐Manufacturing Process ☐Past Due ☐Pressure/Forced ☐Bending ☐Centre Not Concentric ☐Cracks ☐Crimp/Kink/Ripple/Wave ☐Cuffs ☐Crushing ☐Heat Treat ☐Wave/Twist in Tube ☐Marks/Chatter ☐

OTHER :

FAULT CATEGORY

Temperature/Cure ☐Set-up ☐BOM/Route ☐Broken/Damage/Defect ☐Inspection Incomplete/Unqualified ☐Contamination ☐Countersink ☐Cut Too Short ☐Instructions Incomplete/Unclear ☐Drill Holes ☐Power Loss/Surge ☐Folio/Program ☐Grain ☐Weld ☐Wrong Stock Pulled ☐Out of Sequence ☐Off-set ☐Mislabeled ☐Fit/Function ☐Misaligned/off center ☐Positioned Wrong ☐Outside Dimensions ☐Over/Under tolerance ☐Part Incorrect ☐Part Lost/Missing ☐Part Moved ☐Drawing ☐Finish ☐Misread ☐Turning Sequence ☐